

Work Order ID 60803

Friday, July 23, 2010 8:16:12 AM



Page 1

Item ID: D4021-9

Accept



Setup Start



Revision ID:

Item Name: Bushing

Stop



Start Date: 7/23/2010 Start Qty: 16.00



Cust Item ID:

Required Date: 7/29/2010 Req'd Qty: 16.00



Customer:

Reference:

Approvals: Process Plan: 14

Date: 10-7-23 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4021

B

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

TURN AS PER FOLIO FA 868 AND DWG D4021

DWG REV:

FOLIO REV: B

SA 10/07/27

DEBURR

16 ϕ

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SA 10/07/27

16 ϕ

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector | |
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| | | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | | |
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NOTE: Date & initial all entries

Work Order ID 60803

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Page 2

Item ID: D4021-9

Accept

Setup Start

Revision ID:

Stop

Item Name: Bushing

Start Date: 7/23/2010 Start Qty: 16.00

Cust Item ID:

Required Date: 7/29/2010 Req'd Qty: 16.00

Customer:

Reference:

Run Start

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Quality Control

M.A 10/07/27

16

✓

130

Identify as per dwg & Stock Location: LUA

0.00

Packaging

Memo

0.00

Packaging

10/7/27

16x2

140

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

10/07/28

10-7-28
16

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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NOTE: Date & initial all entries

Picklist Print

Friday, July 23, 2010 8:16:17 AM

Page 1

Work Order ID: 60803



Parent Item: D4021-9



Parent Item Name: Bushing



Start Date: 7/23/2010

Required Date: 7/29/2010

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A NEW ISSUE 09-11-23 JLM VERIFIED BY:DD IPP
Rev:B as per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:C as
per dwg revB DD 10.04.20 verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|---|--------------|---------------|----------------|--------|
| M304R.500  | | Purchased | No | | | 100 | f | 4.7100 | 0.083 | 1.397895 | | | |
| 304 SS roundbar .500 | | | | | | | | |  | | | | |

Location

Loc Qty

Loc Code

MAT029

4.71

113006

4.71

1.2 ft SA 10/07/27

| W/O: | | WORK ORDER CHANGES | | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
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NOTE: Date & initial all entries

| W/O: | | | WORK ORDER CHANGES | | | | | |
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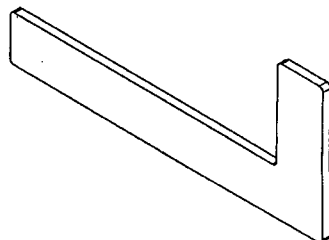
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

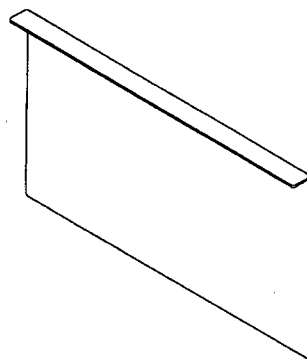
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NOTE: Date & initial all entries

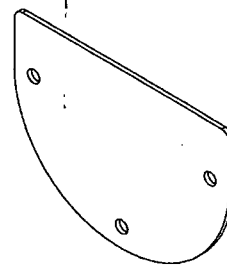
8 7 6 5 4 3 2 1



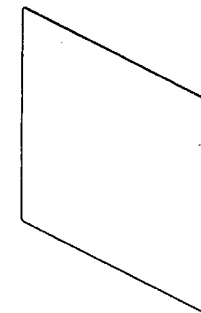
D4021-1 HANDLE PLATE



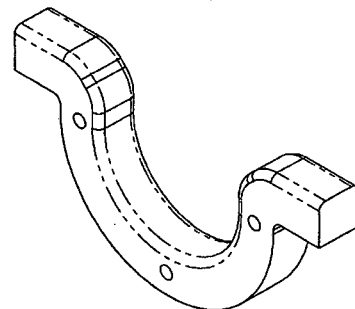
D4021-3 DATA PLATE



D4021-5 BLANKING PLATE



D4021-11 INSTRUCTIONS PLATE



D4021-7 HOOP



D4021-9 BUSHING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60803

BS-0-7-23

RELEASED
2010-04-14
WP

| | | | |
|------------|---|---|----------|
| B | POWDER COAT SPEC ADDED TO NOTE 2 (A8-2) | JPH | 10.04.06 |
| A | NEW ISSUE | JPH | 10.01.28 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JPH | DRAWING NO. D4021 | REV. B |
| CHECKED | <i>[Signature]</i> | SHEET 1 OF 3 | |
| MFG. APPR. | <i>[Signature]</i> | TITLE | SCALE |
| APPROVED | <i>[Signature]</i> | MISC PARTS - 350 BASKET | |
| DE APPR. | <i>[Signature]</i> | NTS | |
| DATE | 10.04.06 | <small> COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small> | |

8 7 6 5 4 3 2 1

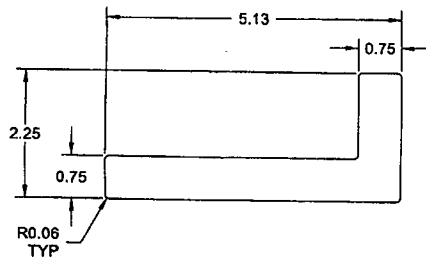
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

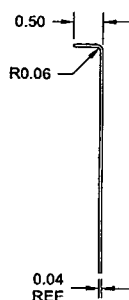
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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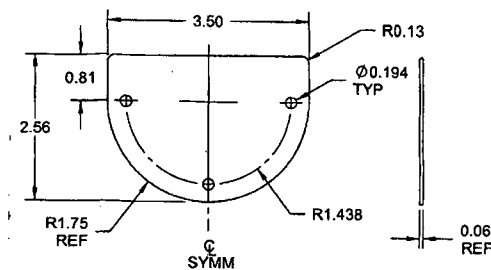
NOTE: Date & initial all entries



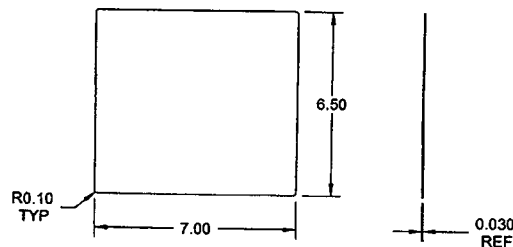
D4021-1 HANDLE PLATE



D4021-3 DATA PLATE
MAKE FROM D4021-3F



D4021-5 BLANKING PLATE



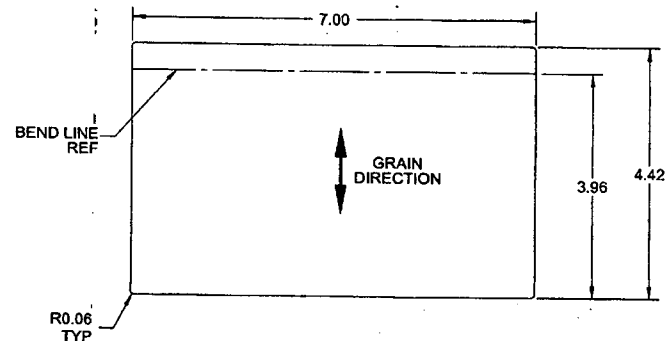
D4021-11 INSTRUCTIONS PLATE

NOTES:

- 1) MATERIAL -1: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA
- 3F: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S20GA
- 5: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M303S16GA OR M304S16GA
- 11: 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S22GA

- 2) FINISH: -1/-3/-11: NONE
-5: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.18 lbs
-3: 0.35 lbs
-5: 0.14 lbs
-11: 0.39 lbs

w/o 60803



D4021-3F DATA PLATE
FLAT PATTERN

RELEASED
2010-04-14
AMP

| | | | |
|------------|--------------------|--|--------|
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | JPH | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D4021 | REV. B |
| MFG. APPR. | <i>[Signature]</i> | SHEET 2 OF 3 | |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | MISC PARTS - 350 BASKET | |
| DATE | 10.04.06 | NTS | |

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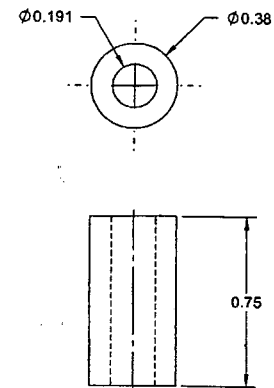
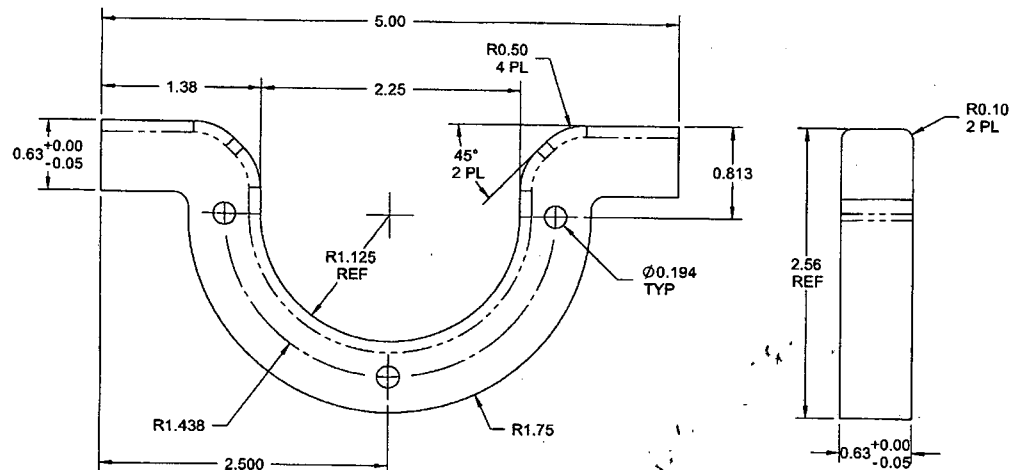
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries



D4021-9 BUSHING

D4021-7 HOOP

NOTES:

- 1) MATERIAL-7: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B
- 9: 304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276
REF DART SPEC M304R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -7: 0.80 lbs
-9: 0.02 lbs

w/o 60803

RELEASED
2010-04-14
NR

| | | | |
|--|--------------------|--|--------------|
| DESIGN | AJS | DART AEROSPACE LTD | |
| DRAWN | JPH | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | <i>[Signature]</i> | D4021 | SHEET 3 OF 3 |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | MISC PARTS - 350 BASKET | NTS |
| DATE | 10.04.06 | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
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NOTE: Date & initial all entries